

Date: Friday, 30/05/2008 10:13:10 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	OUTER FWD SADDLE
Job Number :	39603		
Estimate Number :	11076		
P.O. Number :		Part Number :	D5951
This Issue :	30/05/2008	Drawing Number :	D5951 REV.B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	B
Previous Run :	39196	Material :	
Written By :		Due Date :	15/06/2008
Checked & Approved By :	<u>ND 08-5-30</u>	Qty:	6
Comment :	Est Rev:E Re-Format 05-11-29 JLM	Um:	Each
	Est Rev:E Re-Format 05-11-29 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101013	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

D6101-013 (7075-T7351)

Size 2.50" x 10.10" X 8.25" (Grain along 10.10")

Batch: B38696

DTP 08/06/07 (6)

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5951, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

DTP 08/06/07 (6)

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

DTP 08/06/07 (6)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/06/16 (6)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FR 08/06/16 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:13:10 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 39603

Part Number: D5951

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M107925



(6X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:30
320°F
2:00

md

08/06/16

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-16

(26)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST421

JS

08/06/17

(26)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



L 08-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39603
Description: Outer Fwd Saddle		Part Number: D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		0.444	0.443	0.443	0.443		
B	1.745	1.755		1.749	1.749	1.750	1.749		
C	5.245	5.255		5.249	5.249	5.250	5.251		
D	6.995	7.005		7.000	7.000	7.001	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.749	4.749	4.749	4.750		
G	0.315	0.322		0.322	0.322	0.322	0.322		
H	1.522	1.532		1.526	1.527	1.527	1.526		
I	3.048	3.058		3.051	3.052	3.053	3.052		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.322	0.322	0.322	0.322		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.5005	0.501	0.501	0.5015		
N	1.615	1.635		1.626	1.625	1.625	1.624		
O	7.990	8.010		8.001	8.001	8.000	8.000		
P	2.240	2.260		2.250	2.248	2.2485	2.249		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.502	0.503	0.504	0.503		
T	1.375	1.395		1.3865	1.386	1.3875	1.389		
U	2.000	2.020		2.000	2.0035	2.006	2.0065		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: <u>DTI</u>
Date: <u>08/06/07</u>

Audited by: <u>S</u>
Date: <u>08/06/10</u>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

DART AEROSPACE LTD		Work Order: 39603
Description: Outer Fwd Saddle		Part Number: D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	3	4		
A	0.437	0.444		0.443	0.443				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.245	5.250				
D	6.995	7.005		6.999	7.000				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.749	4.749				
G	0.315	0.322		0.322	0.322				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.580	4.580				
K	0.315	0.322		0.322	0.322				
L	0.495	0.505		0.500	0.500				
M	0.490	0.510		0.4995	0.499				
N	1.615	1.635		1.624	1.623				
O	7.990	8.010		8.000	8.000				
P	2.240	2.260		2.248	2.247				
Q	0.307	0.312		0.310	0.310				
R	0.760	0.765		0.760	0.760				
S	0.490	0.510		0.495	0.499				
T	1.375	1.395		1.3855	1.3855				
U	2.000	2.020		2.0045	2.004				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DTP
Date: 08/06/09

Audited by: [Signature]
Date: 08/06/09

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
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D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

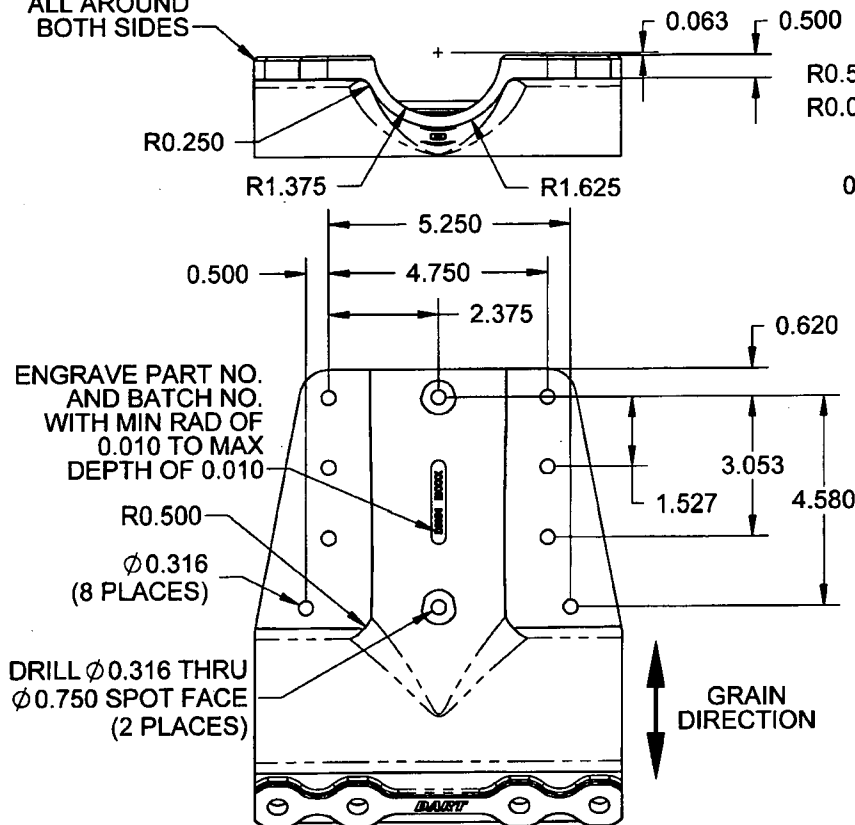
DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5951	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER FWD SADDLE SCALE 1:4		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;	

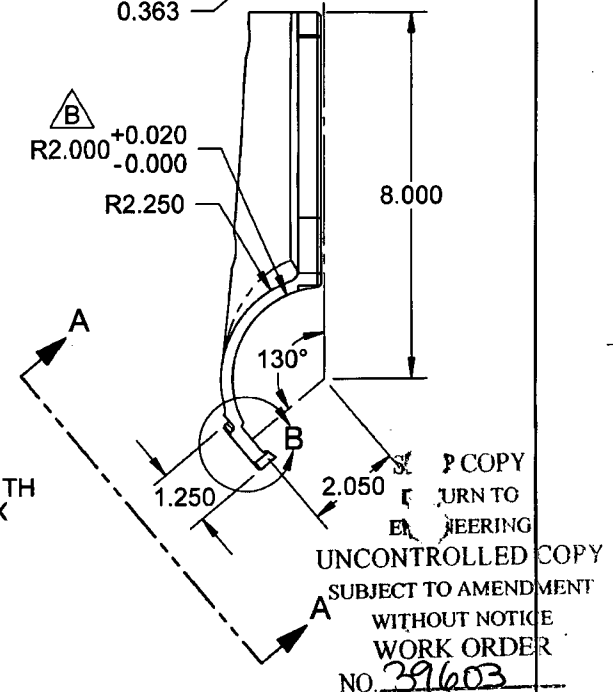
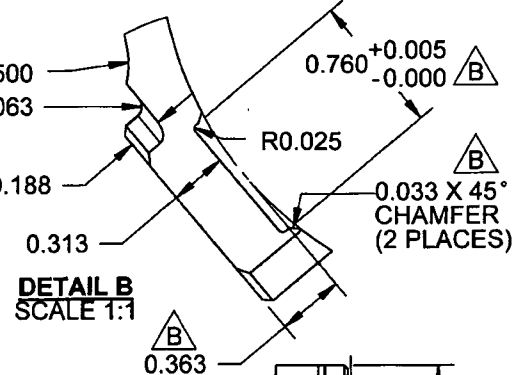
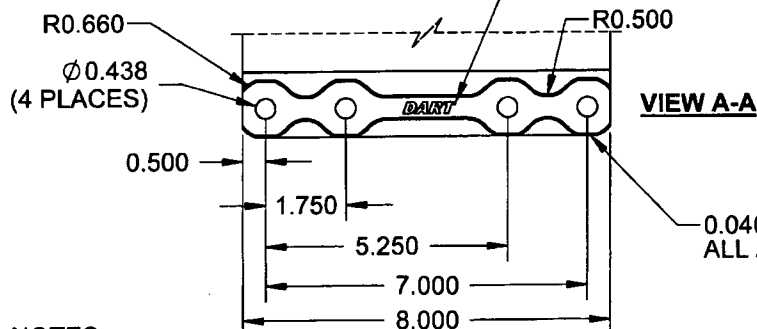
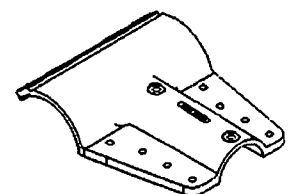
CHAMFER
0.075 X 45°
ALL AROUND
BOTH SIDES

RELEASED

06.11.28



ENGRAVE DART LOGO WITH
MIN RAD OF 0.250 TO MAX
DEPTH OF 0.015

**D5951 OUTER FWD SADDLE**

ISOMETRIC VIEW
SCALE 1:8

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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